

151.20

DART AEROSPACE LTD	Work Order:	23017
Description: Handle Assembly	Part Number:	D3331-041
Dwg: D3331 Rev. B	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.13	10
2	MFA	Cut handle to finish length as per Dwg D3331 Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall (M1025TR0.875W.125) Identify for D3331-1 Batch: M17014	CPL	05/04/26	10
3	MFA	Form as per Dwg D3331 using DT8760 crimping Jig	CPL	05/04/26	10
4	CL	Turn as per Dwg D3331	CPL	05/04/26	10
5	QC2	Inspect parts as they come off the machine Identify as D3331-1	BL	05/04/26	10
6	QC8	Second check	MA	05/04/26	10
7	MC	Deburr	CPL	05/04/26	10
8	MFA	Drill dowel hole as per Dwg D3331	CPL	05/04/26	10
9	MFA	Insert and Weld dowel as per Dwg D3331 Pick: Qty Part Number Description Batch 1 3/16"-1" long Dowel M16922 A/R N/A Steel Rod M9326	CPL	05/04/26	10
10	QC5	Inspect work to Step 9	MA	05/04/27	10
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	MM	05.04.29	10
12	QC3	Inspect Powder Coat	li	05.04.29	10
14	MFA	Assemble as per Dwg D3331 Pick: Qty Part Number Description Batch 1 GP-78R Black Vinyl Grid M17355	PL	05.04.29	10
15	QC5	Inspect work to Step 14	PL	05.04.29	10
16	ST	Identify and Stock	CL	05/05/02	10
17	AC	Cost / part: 25.90	5ar	05-05-05	10
18	DC	Close W/O 25.67 Inspect Level 21	KJ	05.05.10	10

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.03	Revised Step 4 & 5	KJ/JLM	

RELEASED
05.03.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

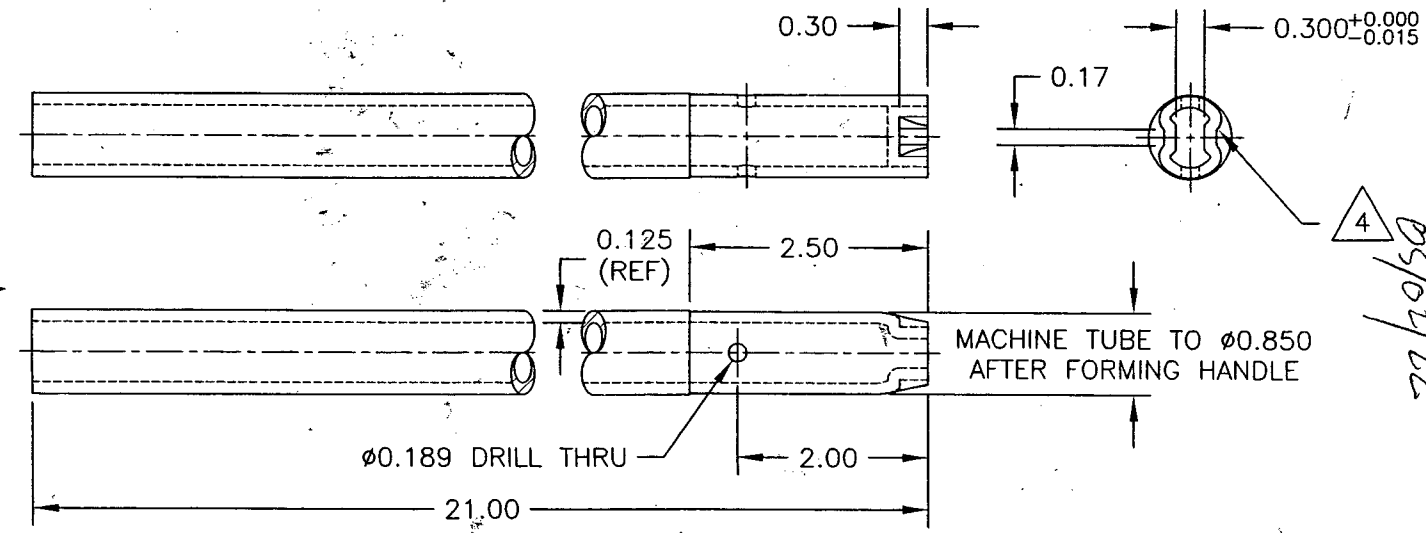
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

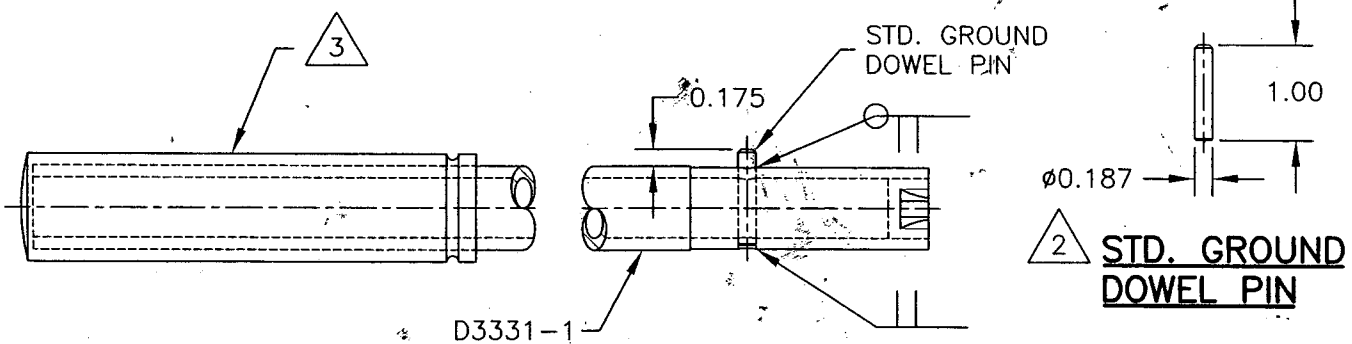
DECLASSIFIED

05/02/22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED KF	APPROVED 	DRAWING NO. D3331	REV. B SHEET 1 OF 1
DATE 05.02.18	TITLE HANDLE WELDMENT SCALE 1:2		
A	04.11.29	NEW ISSUE	
B	05.02.18	LENGTH 21.00 WAS 18.00	



1 D3331-1 HANDLE



D3331-041 HANDLE ASS'Y

- NOTES:
- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR0.875W.125)
 - 2) STD. GROUND DOWEL PIN, $\phi 3/16"$ x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
 - 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
 - 4) FORM USING TOOLING DT8760
 - 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
 - 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 7) ALL DIMENSIONS ARE IN INCHES
 - 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

NO. 23017

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023017
Project Name : D3331-041
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3331-041
Description : Handle Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00